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(71) Applicant: **Goodrich Corporation**
Charlotte, NC 28217-4578 (US)

(72) Inventors:
• **SLANE, Casey**
Tallmadge, OH Ohio 44278 (US)
• **CHING, Nathaniel**
Hartville, OH Ohio 44632 (US)

- **ZHAO, Wenping**
Glastonbury, CT Connecticut 06033 (US)
- **WAINA, Daniel**
Uniontown, OH Ohio 11685 (US)
- **HU, Jin**
Hudson, OH Ohio 44236 (US)
- **HEIN, Brandon**
Stow, OH Ohio 44224 (US)
- **OWENS, George F.**
Akron, OH Ohio 44319 (US)
- **MULLEN, James A.**
Wadsworth, OH Ohio 44281 (US)

(74) Representative: **Dehns**
St. Bride's House
10 Salisbury Square
London EC4Y 8JD (GB)

(54) **HEATED FLOOR PANEL WITH IMPACT LAYER**

(57) A heated floor panel assembly with an impact layer is made to absorb blunt force and protect a heating element inside the assembly. The assembly further includes a plurality of structural layers (16, 20) made of a reinforced polymer matrix, one or more core layer (18)

with a honeycomb or foam structure for absorbing shear stress, and a heating layer (22) containing the heating element. The impact layer (24) is a composite layer with a resin impregnated fiber matrix.

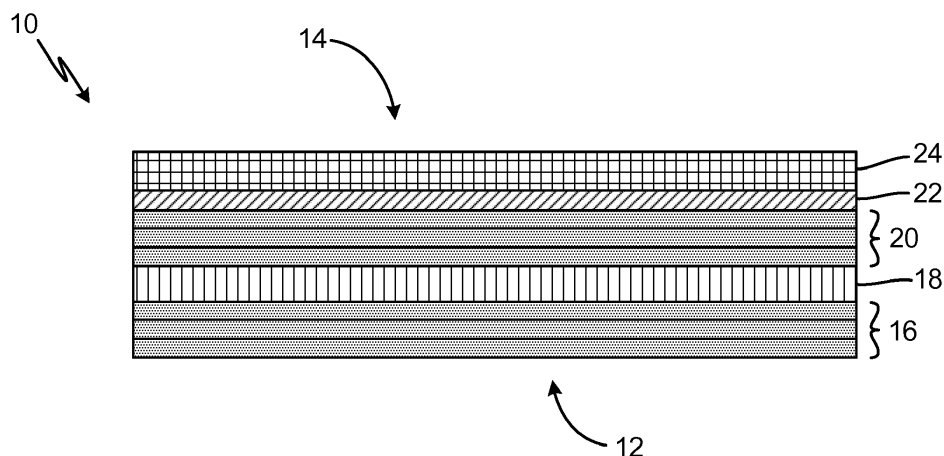


Fig. 1

Description

BACKGROUND

[0001] This application relates generally to heated floor panel assemblies for aircraft, and specifically to impact protection of heated floor panel assemblies.

[0002] Heated floor panels are often used in aircraft to mitigate the effects of cold underfloor temperatures and to help maintain a comfortable cabin temperature. The floor panels are typically supported by an aircraft structure arranged, for example, in a grid-like pattern. The floor panels have structural integrity sufficient to support the weight of people and objects resting on the panels. Heated floor panels must be able to withstand impacts from punctures from high heels, chips from dropped objects, scratches from dragged luggage, and/or other floor-traffic related hazards.

SUMMARY

[0003] A floor panel assembly has a bottom surface and a top surface. The floor panel assembly includes a first stack of structural layers adjacent the bottom surface, a first core layer, adjacent the first stack of structural layers, that absorbs shear stress, a second stack of structural layers between the core layer and the top surface, a heating layer between the core layer and the top surface, and an first impact layer between the heating layer and the top surface. The impact layer includes a fiber matrix and a thermoplastic or elastomer resin infiltrating the fiber matrix. The first stack of structural layers, the core layer, the second stack of structural layers, the heating layer, and the impact layer are bonded together.

BRIEF DESCRIPTION OF THE DRAWINGS

[0004]

FIG. 1 is a schematic diagram of a heated floor panel assembly.

FIG. 2 is a schematic diagram of a heated floor panel assembly in a second embodiment.

FIG. 3 is a schematic diagram of a heated floor panel assembly in a third embodiment.

FIG. 4 is a schematic diagram of a heated floor panel assembly in a fourth embodiment.

DETAILED DESCRIPTION

[0005] The present invention is directed to a composite panel, and more specifically, to a heated floor panel assembly with increased impact protection. The panel includes structural layers, at least one core layer for absorbing shear stress, and at least one impact layer for absorbing blunt force, in addition to a heating layer containing a heating element. The impact layer can be infiltrated with fibers or wires to increase blunt impact resist-

ance, or impregnated with a high toughness elastomeric resin. Multiple core layers or multiple impact layers can be used to increase impact resistance of the assembly. Alternatively, the heating layer can be moved further within the heated floor panel assembly to protect the heating element.

[0006] FIG. 1 is a schematic diagram of heated floor panel assembly 10 having bottom surface 12 and top surface 14. Assembly 10 contains first stack of structural layer 16, core layer 18, second stack of structural layers 20, heating layer 22, and impact layer 24. Assembly 10 can be held together by film adhesives (not shown) as needed between the components.

[0007] Bottom surface 12 of assembly 10 is anchored to an aircraft, while top surface 14 faces the inside of an aircraft cabin or other floor area needing to be heated. Components 16, 18, 20, 22, and 24 are arranged between bottom surface 12 and top surface 14. First stack of structural layers 16 is attached to bottom surface 12. Core layer 18 is attached to first stack of structural layers 16 opposite bottom surface 12. Second stack of structural layers 20 is attached to core layer 18 opposite first stack of structural layers 16. Heating layer 22 is attached to second stack of structural layers 20 opposite core layer 18. Impact layer 24 is attached to heating layer 22 opposite second stack of structural layers 20. Impact layer 24 faces top surface 14.

[0008] Stacks of structural layers 16 and 20 provide reinforcement to assembly 10. Stacks of structural layers 16 and 20 can be a reinforced polymer, such as a carbon fiber or fiberglass impregnated with a resin system such as a thermoplastic (polyether ether ketone, polycarbonate, polyphenylene sulfide, polyetherimide) or a thermoset (epoxy, phenolic, bismaleimide, benzoxazine). Each of stacks of structural layers 16 and 20 can include a single ply, or a stack of plies, depending on, for example, the material chosen to form the structural layers, or the particular need for reinforcement. Additional and/or alternative structural layers can also be added in other embodiments.

[0009] Core layer 18 carries shear loads to stiffen floor panel assembly 10. Core layer 18 can, in an exemplary embodiment, be formed from a high density metallic material, such as aluminum alloy, stainless steel, or titanium, and can further be arranged in a honeycomb structure. Alternatively, core layer 18 can be formed from an expanded honeycomb polymer, such as resin-infused aramids (e.g., Kevlar® or Nomex®), resin-infused carbon fiber or fiberglass, thermoplastic tubing, as well as an open-cell or closed-cell polymer foam. Infusing resins could be epoxy, phenolic, or cyanate ester. Generally, a metallic core layer has greater thermal conductivity than a polymer core layer.

[0010] Heating layer 22 can include an electric heating element (not shown). The heating element can be a resistive heating element formed, for example, from a metallic material, Positive Temperature Control (PTC) ceramic, PTC polymer, or carbon allotrope material such

as a carbon nanotube (CNT) heater. The heating element can be arranged as an etched foil, wire, or printed-ink element. Other suitable heating elements are contemplated herein. Heating layer 22 can be used to control the temperature of top surface 14 of assembly 10, which can be installed, for example, in an aircraft cabin or cockpit. In certain embodiments, the heating element can extend across the entire area of heating layer 22. In other embodiments, the heating element can be inset some distance from the edges of heating layer 22 in order to protect the element from fluid spills along or damage at the edges of assembly 10.

[0011] In prior art embodiments, an impact layer is typically a monolithic material, such as a monolithic metal or a monolithic polymer. In assembly 10, impact layer 24 is a resin-impregnated metal, or a polymer fabric. For instance, impact layer 24 can contain both a fiber matrix and a resin. The fiber matrix of impact layer 24 can be made of fiberglass or carbon fiber materials, a thermoplastic fiber, or a metallic fiber. The resin of impact layer 24 can be a thermoplastic or a thermoset, preferably a resin with a high toughness. Additionally, impact layer 24 can be reinforced with other fibers. Other suitable high-strength, and low-density materials are contemplated herein.

[0012] The thermoplastic or elastomer resin of impact layer 24 is a high toughness resin, such as thermoset or a thermoplastic. These types of resins have an ability to stretch to allow deformation while keeping the core sealed from the environment. Impact layer 24 is preimpregnated, meaning the fiber matrix of impact layer 24 is filled with the high toughness resin prior to assembly of floor panel assembly 10. The materials of impact layer 24 cannot suffer permanent degradation in the full range of temperatures experienced in an aircraft interior, which is typically between -55 °C and 85 °C.

[0013] Examples of appropriate thermoplastic or elastomer high toughness resins include thermoplastics such as polyetheretherketone, polyaryletherketones, polycarbonate, polyphenylene sulfide, polyetherimide, polyimide, polymethylmethacrylate (acrylic), polyvinylchloride, polyurethane, and polyamideimide; or thermosets such as epoxy, phenolic, BMI, benzoxazine, or polyurethane. The resin should both allow for ductility and mechanical strength. Typical elongation to break is 30% to 150% and breaking strength is 30 MPa to 120 MPa. The density of the resin is typically 0.9 to 1.7 grams per cubic centimeter.

[0014] Additionally, impact layer 24 can be reinforced with other fibers such as aramid fibers (Kevlar®, Nomex®), fiberglass, basalt fibers, carbon fiber, carbon nanotube, nano steel fibers, or wires such as titanium or steel wires. Such fibers (or wires) can provide mechanical support to impact layer 24, spread impact forces, and prevent damage from blunt impact.

[0015] FIG. 2 is a schematic diagram of heated floor panel assembly 26. Assembly 26 has many of the same components as assembly 10 in FIG. 1, but arranged in a different configuration.

[0016] Here, as in assembly 10, bottom surface 12 of assembly 10 is anchored to an aircraft, while top surface 14 faces the inside of an aircraft cabin or other floor area needing to be heated. Components 16-24 are arranged between bottom surface 12 and top surface 14. First stack of structural layers 16 is attached to bottom surface 12. Core layer 18 is attached to first stack of structural layers 16 opposite bottom surface 12.

[0017] However, heating layer 22 is attached to core layer 18 opposite first stack of structural layers 16. Because of this, second stack of structural layers 20 are attached to heating layer 22 opposite core layer 18, and impact layer 24 is attached directly to second stack of structural layers 20. Impact layer 24 faces top surface 14. The location of heating layer 22 adjacent core layer 18, underneath stack of structural layers 20 provides additional protection for the heating element on heating layer 22.

[0018] FIG. 3 is a schematic diagram of heated floor panel assembly 28. Assembly 28 has many of the same components as assembly 10 in FIG. 1, but arranged in a different configuration. Assembly 28 additionally contains second core layer 30.

[0019] Here, heating layer 22 is sandwiched between first core layer 18 and second core layer 30. This allows for further cushioning of heating layer 22. Core layers 18 and 30 can take stress and impacts so that heating layer 22 lasts longer than heating layers protected located closer to an impact layer. As with assembly 10, core layers 18 and 30 provide impact resistance to assembly 10, and carry shear loads to stiffen floor panel assembly 10.

[0020] Second core layer 30 can, in an exemplary embodiment, be formed from a high density metallic material, such as aluminum alloy, stainless steel, or titanium, and can further be arranged in a honeycomb structure. First core layer 18 can be formed from an expanded honeycomb polymer, such as resin-infused aramids (e.g., Kevlar® or Nomex®), resin-infused carbon fiber or fiberglass, as well as an open-cell or closed-cell polymer foam. Infusing resins could be epoxy, phenolic, or cyanate ester. In this case, metallic second core layer 30 has greater thermal conductivity than polymer first core layer 18, which improves the thermal transfer properties of assembly 10 in the direction of top surface 14, where heating is desired. In another embodiment, however, both core layers 18 and 30 can be formed from the same material (e.g., metal or polymer), and such an arrangement will depend on factors such as weight limitations and panel heating or insulation requirements.

[0021] FIG. 4 is a schematic diagram of heated floor panel assembly 32. Assembly 32 has many of the same components as assembly 28 in FIG. 3, but additionally contains second impact layer 34. Here, first stack of structural layers 20 are attached between first impact layer 24 and second impact layer 34. First stack of structural layers 20 support second impact layer 34, attached to assembly 10 on top surface 14. Meanwhile, first impact layer 24 is embedded within assembly 32 adjacent core lay-

er 30.

[0022] Like first impact layer 24, Second impact layer 34 contains both a fiber matrix and a resin. The materials for impact layers 24 and 34 are discussed in more depth in regards to impact layer 24. The fiber matrix of impact layer 34 can be made of fiberglass or carbon fiber. Other suitable high-strength, high-stiffness, and low-density materials are contemplated herein. The resin of impact layer 34 can be a thermoset or a thermoplastic, just as in impact layer 24.

[0023] The use of a composite impact layer with a resin impregnated fiber matrix is a lighter, more efficient impact layer for heated floor panel assembly protection. The use of reinforcing fibers or wires further protects the heated floor panel assembly from blunt impact or force. In some embodiments, additional structural, core, or impact layers further protect the heating element without adding significant weight.

Discussion of Possible Embodiments

[0024] The following are non-exclusive descriptions of possible embodiments of the present invention.

[0025] A floor panel assembly has a bottom surface and a top surface. The floor panel assembly includes a first stack of structural layers adjacent the bottom surface, a first core layer, adjacent the first stack of structural layers, that absorbs shear stress, a second stack of structural layers between the core layer and the top surface, a heating layer between the core layer and the top surface, and an first impact layer between the heating layer and the top surface. The impact layer includes a fiber matrix and a resin infiltrating the fiber matrix. The first stack of structural layers, the core layer, the second stack of structural layers, the heating layer, and the impact layer are bonded together.

[0026] The assembly of the preceding paragraph can optionally include, additionally and/or alternatively, any one or more of the following features, configurations and/or additional components:

The first and second stacks of structural layers comprise a reinforced polymer matrix comprising a structural fiber matrix impregnated with a structural resin.

[0027] The structural fiber matrix is a carbon fiber or fiberglass.

[0028] The structural resin is polyether ether ketone, polycarbonate, polyphenylene sulfide, polyetherimide, epoxy, phenolic, bismaleimide, benzoxazine, or combinations thereof.

[0029] The first core layer comprises a high density metallic material in a honeycomb structure selected from the group consisting of aluminum alloys, stainless steel, and titanium.

[0030] The first core layer comprises an expanded honeycomb polymer, an open-cell polymer foam, or closed-cell polymer foam.

[0031] The heating layer comprises a metallic material, Positive Temperature Control (PTC) ceramic, PTC pol-

ymers, or carbon allotrope material.

[0032] The fiber matrix of the impact layer comprises fiberglass, carbon fiber, thermoplastic fiber, or metallic fiber.

[0033] The resin of the impact layer is selected from the group consisting of polyetheretherketone, polyaryletherketones, polycarbonate, polyphenylene sulfide, polyetherimide, polyimide, polymethylmethacrylate (acrylic), polyvinylchloride, polyurethane, and polyamideimide, epoxy, phenolic, BMI, benzoxazine, and polyurethane.

[0034] The thermoplastic resin has an elongation to break of 30% to 150%.

[0035] The thermoplastic resin has a breaking strength of 30 MPa to 120 MPa.

[0036] The thermoplastic resin has a density of 0.9 g/cm³ to 1.7 g/cm³.

[0037] The impact layer further comprises reinforcements selected from the group consisting of aramid fibers, fiberglass, basalt, carbon fiber, carbon nanotube, nano steel, steel wire, titanium wire, and combinations thereof.

[0038] The impact layer does not exhibit degradation due to temperature between temperature of -55 °C and 85 °C.

[0039] The heating layer is adjacent the impact layer.

[0040] The heating layer is adjacent the core layer.

[0041] The floor panel assembly includes a second core layer, wherein the heating layer is sandwiched by the first core layer and the second core layer.

[0042] The second core layer comprises a high density metallic material in a honeycomb structure, an expanded honeycomb polymer, an open-cell polymer foam, or closed-cell polymer foam.

[0043] The first core layer comprises a material different than the second core layer.

[0044] The floor panel assembly includes a second impact layer between the first stack of structural layers and the core layer.

[0045] While the invention has been described with reference to an exemplary embodiment(s), it will be understood by those skilled in the art that various changes may be made and equivalents may be substituted for elements thereof without departing from the scope of the invention as defined by the claims. In addition, many modifications may be made to adapt a particular situation or material to the teachings of the invention without departing from the scope of the claims. Therefore, it is intended that the invention not be limited to the particular embodiment(s) disclosed, but that the invention will include all embodiments falling within the scope of the appended claims.

Claims

1. A floor panel assembly having a bottom surface (12) and a top surface (14), the floor panel assembly com-

prising:

a first stack of structural layers (16) adjacent the bottom surface;
 a first core layer (18), adjacent the first stack of structural layers, that absorbs shear stress;
 a second stack of structural layers (20) between the core layer and the top surface;
 a heating layer (22) between the core layer and the top surface; and
 an first impact layer (24) between the heating layer and the top surface, the impact layer comprising:

a fiber matrix; and
 a thermoplastic resin infiltrating the fiber matrix;

wherein the first stack of structural layers, the core layer, the second stack of structural layers, the heating layer, and the impact layer are bonded together.

2. The floor panel assembly of claim 1, wherein the first and second stacks of structural layers comprise a reinforced polymer matrix comprising a structural fiber matrix impregnated with a structural resin.
3. The floor panel of claim 2, wherein the structural fiber matrix is a carbon fiber or fiberglass.
4. The floor panel of claim 2 or 3, wherein the structural resin is polyether ether ketone, polycarbonate, polyphenylene sulfide, polyetherimide, epoxy, phenolic, bismaleimide, benzoxazine, or combinations thereof.
5. The floor panel assembly of any preceding claim, wherein the first core layer comprises a high density metallic material in a honeycomb structure selected from the group consisting of aluminum alloys, stainless steel, and titanium, or wherein the first core layer comprises an expanded honeycomb polymer, an open-cell polymer foam, or closed-cell polymer foam.
6. The floor panel assembly of any preceding claim, wherein the heating layer comprises a metallic material, Positive Temperature Control (PTC) ceramic, PTC polymer, or carbon allotrope material.
7. The floor panel assembly of any preceding claim, wherein the fiber matrix of the impact layer comprises fiberglass, carbon fiber, thermoplastic fiber, or metallic fiber.
8. The floor panel assembly of any preceding claim, wherein the thermoplastic resin is selected from the

group consisting of polyetheretherketone, polyaryletherketones, polycarbonate, polyphenylene sulfide, polyetherimide, polyimide, polymethylmethacrylate (acrylic), polyvinylchloride, polyurethane, and polyamideimide, epoxy, phenolic, BMI, benzoxazine, and polyurethane.

9. The floor panel assembly of any preceding claim, wherein the thermoplastic resin has an elongation to break of 30% to 150%, and/or wherein the thermoplastic resin has a breaking strength of 30 MPa to 120 MPa; and/or wherein the thermoplastic resin has a density of 0.9 g/cm³ to 1.7 g/cm³.
10. The floor panel assembly of any preceding claim, wherein the impact layer further comprises reinforcements selected from the group consisting of aramid fibers, fiberglass, basalt, carbon fiber, carbon nanotube, nano steel, steel wire, titanium wire, and combinations thereof.
11. The floor panel assembly of any preceding claim, wherein the impact layer does not exhibit degradation due to temperature between temperature of -55 °C and 85 °C.
12. The floor panel assembly of any preceding claim, wherein the heating layer is adjacent the impact layer, or wherein the heating layer is adjacent the core layer.
13. The floor panel assembly of any preceding claim, further comprising a second core layer (30), wherein the heating layer is sandwiched by the first core layer and the second core layer.
14. The floor panel assembly of claim 13, wherein the second core layer comprises a high density metallic material in a honeycomb structure, an expanded honeycomb polymer, an open-cell polymer foam, or closed-cell polymer foam, and preferably wherein the first core layer comprises a material different than the second core layer.
15. The floor panel assembly of any preceding claim, further comprising a second impact layer (34) between the first stack of structural layers and the core layer.

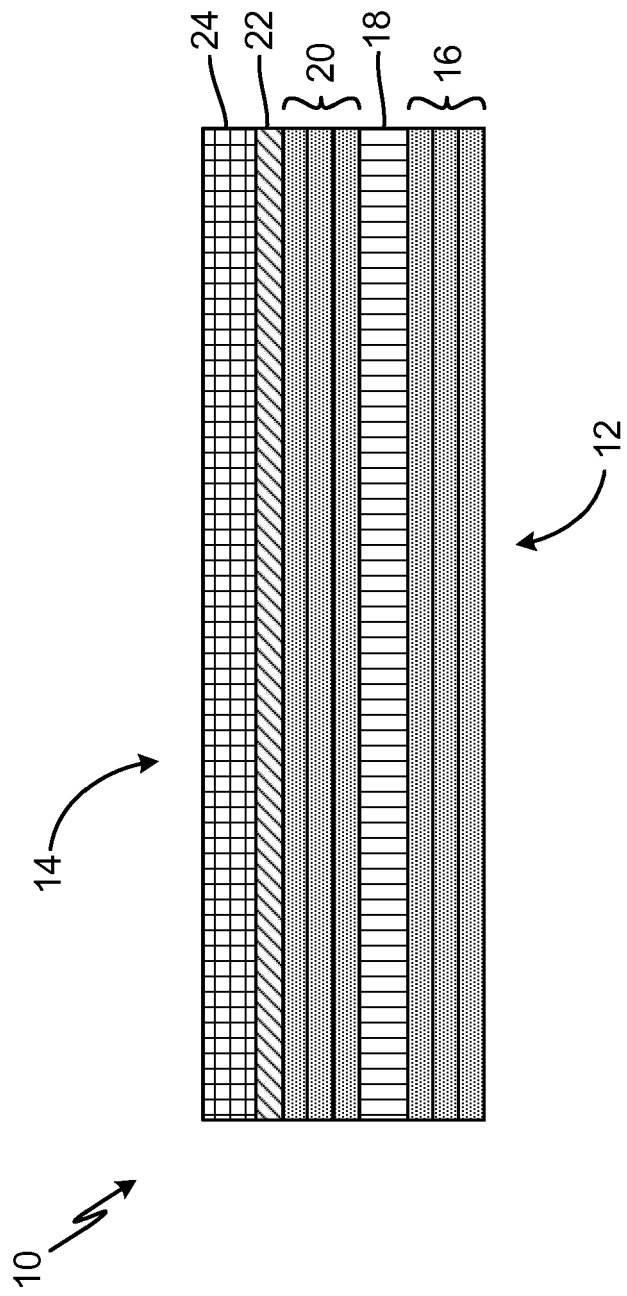


Fig. 1

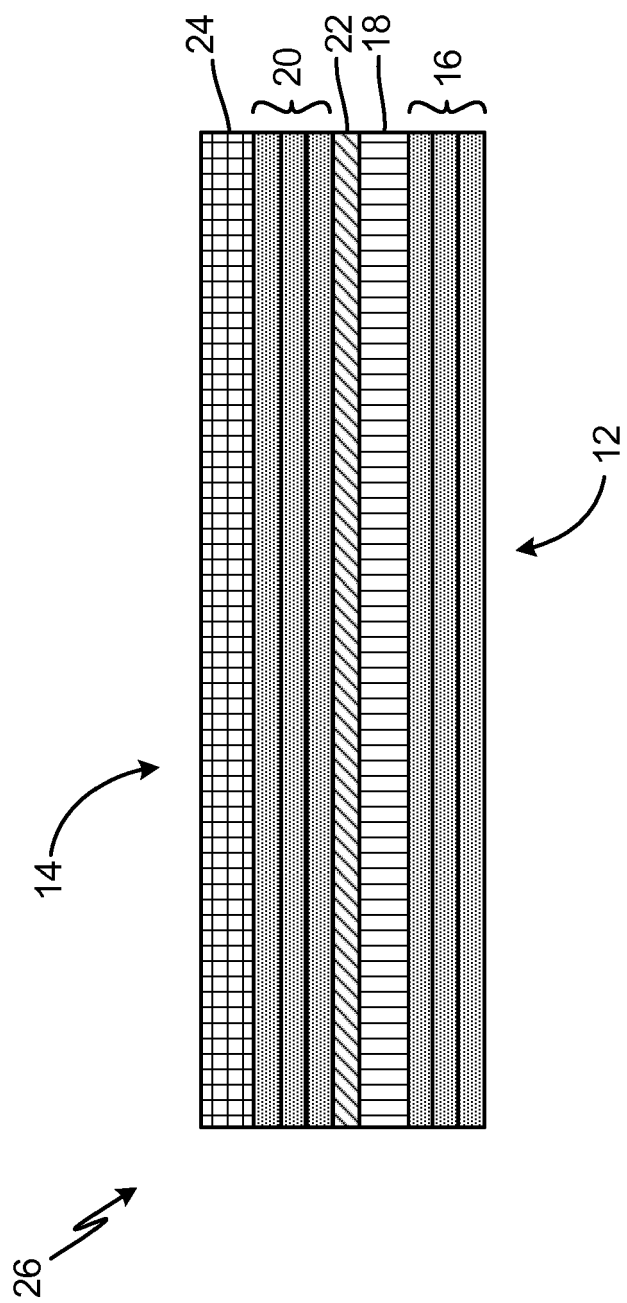


Fig. 2

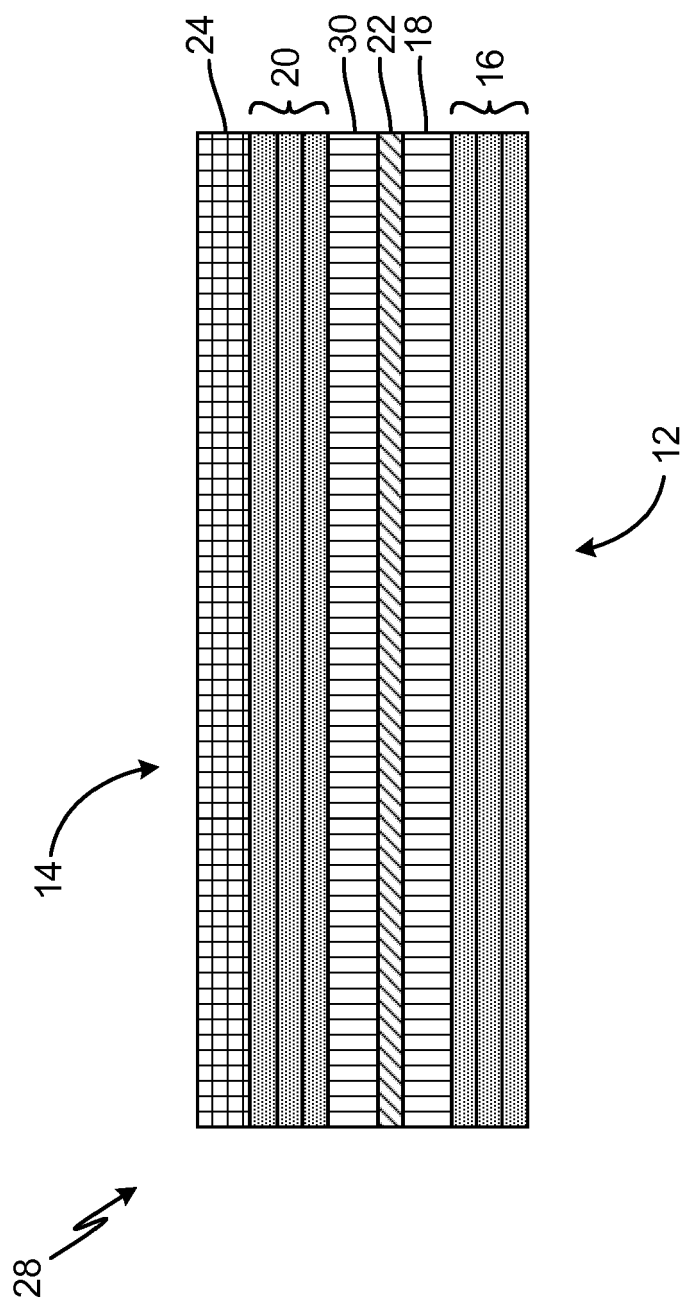


Fig. 3

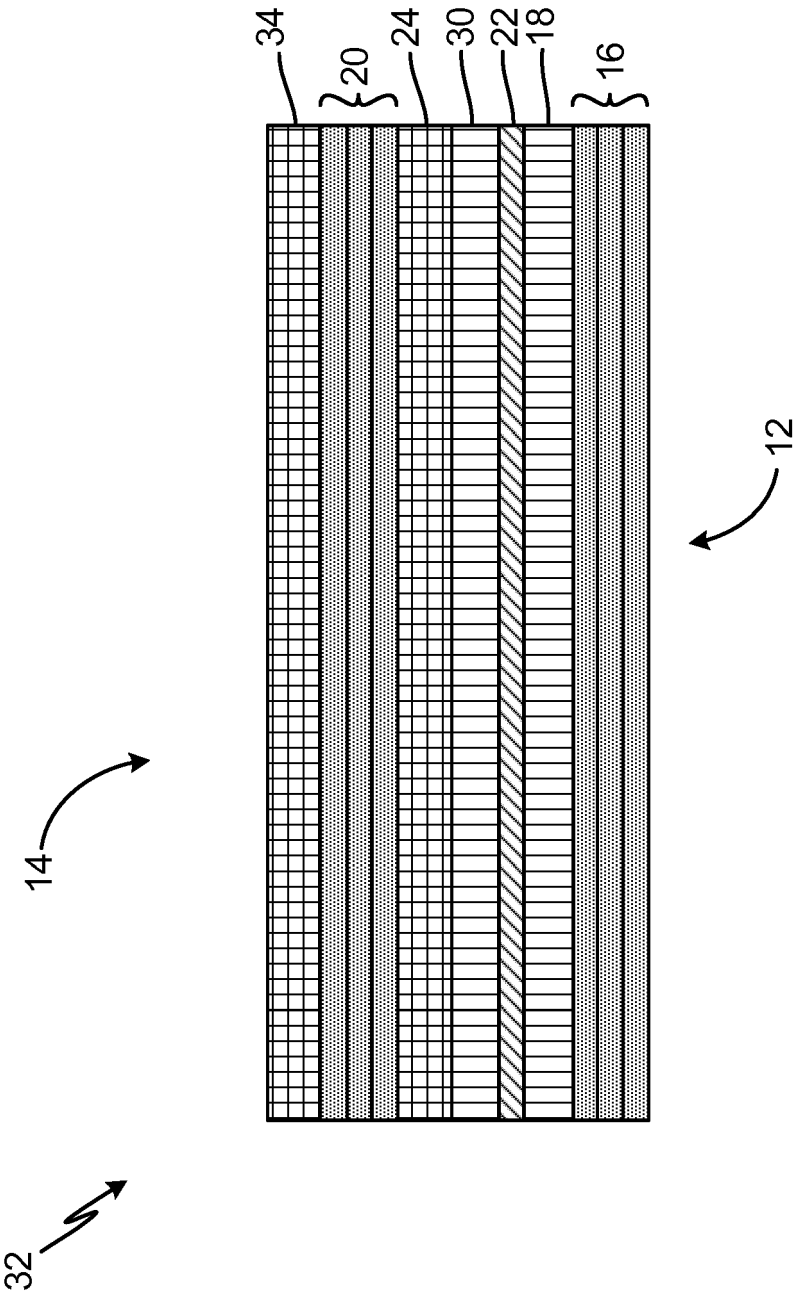


Fig. 4



EUROPEAN SEARCH REPORT

 Application Number
 EP 19 18 4091

DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (IPC)
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			TECHNICAL FIELDS SEARCHED (IPC)
			B32B B64F F24H H05B B64C B64D F24D
The present search report has been drawn up for all claims			
Place of search		Date of completion of the search	Examiner
The Hague		21 November 2019	Hillebrand, Gerhard
CATEGORY OF CITED DOCUMENTS			
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**ANNEX TO THE EUROPEAN SEARCH REPORT
ON EUROPEAN PATENT APPLICATION NO.**

EP 19 18 4091

5 This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report.
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21-11-2019

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